

HAI

## Work Order ID 65599



Page 1

January 20, 2011 10:55:20 AM

Item ID: D4059-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section, Aft RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CLDate: 11/01/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4059

A

100

0.00



Machine Set-up

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Load program D4058 and set-up clamping frame as per folio FTA076

OK OK  
11/01/31 11/01/24

105

0.00



Cut Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

OK OK  
11/01/31 11/01/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65599

January 20, 2011 10:55:20 AM



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Item ID: D4059-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section, Aft RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00



Dry Material

0.00

HandThermo

Memo

Hand Finishing Thermoforming

Dry Sheet as per QSI022 ALEXTRA

Temp: 240°F

240°F

Time IN: 7:00 pm. 11/01/22

7:00 pm 11/01/22

Time OUT: 7:00 am 11/01/24

7:00 am. 11/01/31

OK OK  
11/01/31 11/01/24

120

0.00



Thermoforming

0.00

Thermoform

Memo

Thermoforming Machine

Thermoform as per Dwg. D4058-1 and Folio FTA076 using tool DT 9602

Dwg. Rev. A A

Folio Rev. B C

x1 x2

OK OK  
11/01/24 11/01/31

PTO →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/24	120.						

Part No: D4059-2 PAR #: NA Fault Category: Thermoforming NCR: Yes No DQA: 7 Date: 11/02/07  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>65599</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/01/24	120.	Part did not form. <del>Scrap &amp; Replace</del> R.C. Tooling, positioning	U 11/02/03	Adjust clamping frame to left mould higher into platten <del>Scrap &amp; Replace Part</del> Qty 1	Wh 11/01/24	S 11/02/03	le 11/02/03	S 11/02/03
11/01/24	120.	Part did not form. R.C. process - Folio adjustments.	U 11/02/03	Adjust heat settings update Folio <del>Scrap &amp; Replace</del> Qty 1	Wh 11/01/24	S 11/02/03	U 11/02/03	S 11/02/03

NOTE: Date & initial all entries

**Work Order ID 65599**

January 20, 2011 10:55:20 AM



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Item ID: D4059-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section, Aft RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 QC2- Inspect parts off machine FAI/FAIB 0.00



QC Memo 0.00

Quality Control Visually inspect for proper formation of each part

x1

Dh  
11/01/34

140 QC8- Inspect parts - second check 0.00



QC Memo 0.00

Quality Control

x1

BB 11/02/03  
Dh.  
11/02/03

150 Trim &amp; Drill 0.00



HandThermo Memo 0.00

Hand Finishing Thermoforming 1-Trim to Finished Dimensions as per dwg D4058-1

2- Use 1.25" unibit to drill suction relief  
holes if required

3-Use .375" unibit to drill wearplate and clamp mounting holes as per dwg

x1

Dh  
11/02/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65599

January 20, 2011 10:55:20 AM



Page 4

Item ID:	D4059-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Ski Section, Aft RH					
Start Date:	1/20/11	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/27/11	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandThermo. Hand Finishing Thermoforming	Anneal material  Memo Anneal trimmed & drilled product at 250 deg. F. for 75 minutes & allow to cool in oven.  Time In: <u>2:45 PM</u> <u>11/02/02</u>  Oven Off: <u>4:00 PM</u> <u>11/02/02</u>	0.00  0.00				<u>xl</u>			<u>Wk</u> <u>11/02/02</u>
170  QC Quality Control	QC6- Inspect dimensions to drawing  Memo Check dimensions to ensure conformity to drawing tolerances.	0.00  0.00							<u>n/a</u>
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							<u>8/16/03</u> <u>H</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 65599**

January 20, 2011 10:55:20 AM



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Item ID: D4059-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section, Aft RH

Start Date: 1/20/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/27/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>THERM</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/02/04   
MF

11-02-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 20, 2011 10:55:19 AM

Page 1

Work Order ID: 65599



Parent Item: D4059-2



Parent Item Name: Ski Section, Aft RH

Start Date: 1/20/11

Required Date: 1/27/11

Start Qty: 1.00

Required Qty: 1.00

Comments: New Issue 10/03/16 Rev. A DL verified by:DD IPP Rev B.  
Improved process Add Step 105 (Drying) & 145 (Annealing) to routings  
10/03/31 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M-ALXTRAB-S.300

Purchased

No

sf

336.6290

23.56632



Alextra ET 0.300 sheet

Location

Loc Qty

Loc Code

therm

336.629

113108

336.629

11/02/03 ✓

70.6989 sq ft.

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	65599
<b>Description:</b>		<b>Part Number:</b>	
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>	

**FIRST ARTICLE INSPECTION CHECKLIST**  
**THERMOFORMING SECTION**

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			1 small blemish but OK for HAF

<b>Measured by:</b>	<i>DA</i>	<b>Date:</b>	11/02/01
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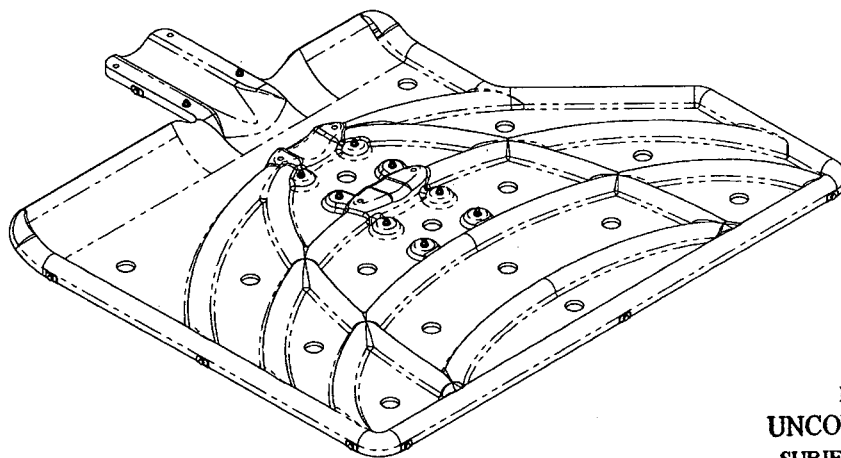
**TRIMMING SECTION**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25"	+ 0.25 - 0.00	1.37"	✓			
0.38"	+ 0.006 - 0.001	0.374"	✓			
1.25"	+ 0.030	1.28"	✓			
0.210"	+ 0.010	0.207"	✓			
0.175"	+ 0.010	0.212"	✓			
44.7"	Ref	44.58"	✓			

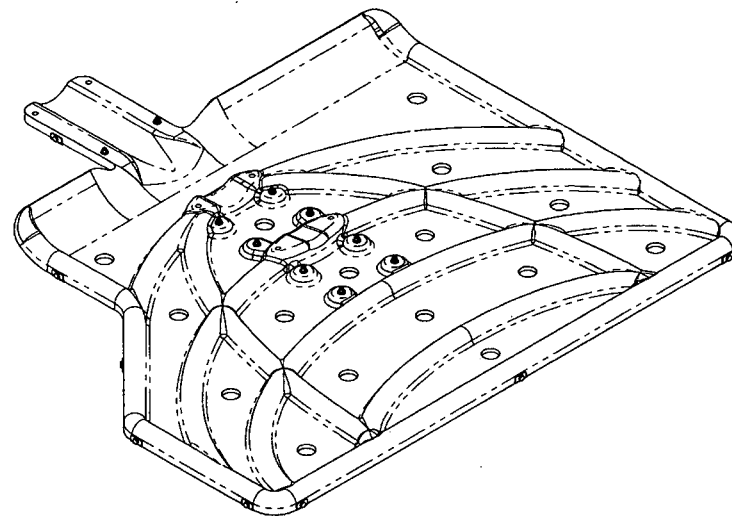
<b>Measured by:</b>	<i>DA</i>	<b>Date:</b>	11/02/03
<b>Audited by:</b>	<i>S</i>	<b>Date:</b>	11/02/03
<b>Preliminary Approval:</b>		<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*10.04.14*



**D4059-041 AFT SKI ASSY, LH**



**D4059-042 AFT SKI ASSY, RH**

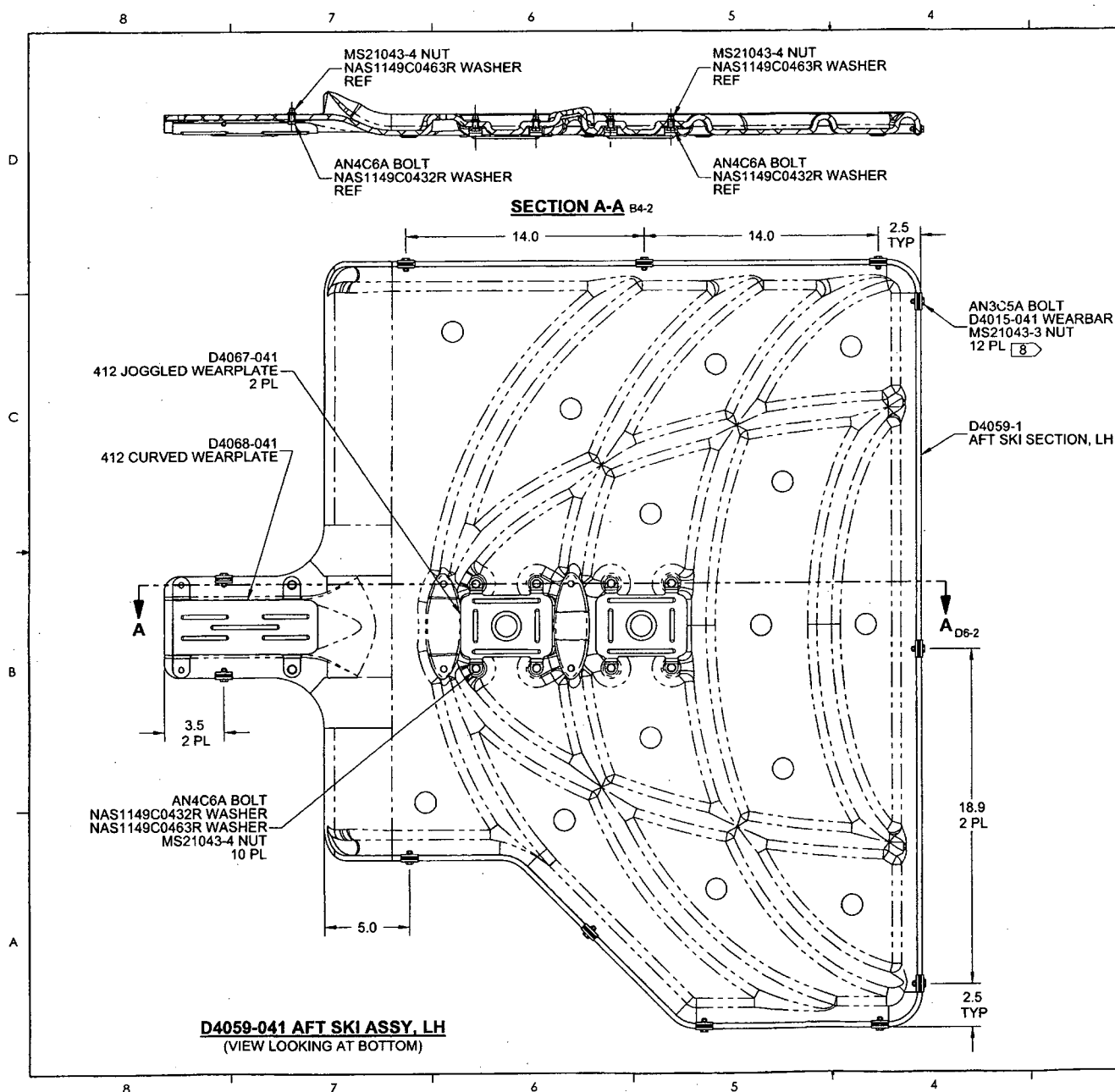
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NO. 65597

*CL 11/01/20*

**RELEASED**  
2010-04-07  
*WJP*

A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.31		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4059</b>	REV. A
TITLE <b>AFT SKI ASSY</b>	SCALE NTS
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-041	AFT SKI ASSY, LH
2	12	D4015-041	WEARBAR
3	1	D4059-1	AFT SKI SECTION
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	10	AN4C6A	BOLT
8	12	MS21043-3	NUT
9	10	MS21043-4	NUT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

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**RELEASED**  
2010-04-07  
MD

**D4059-041 NOTES:**

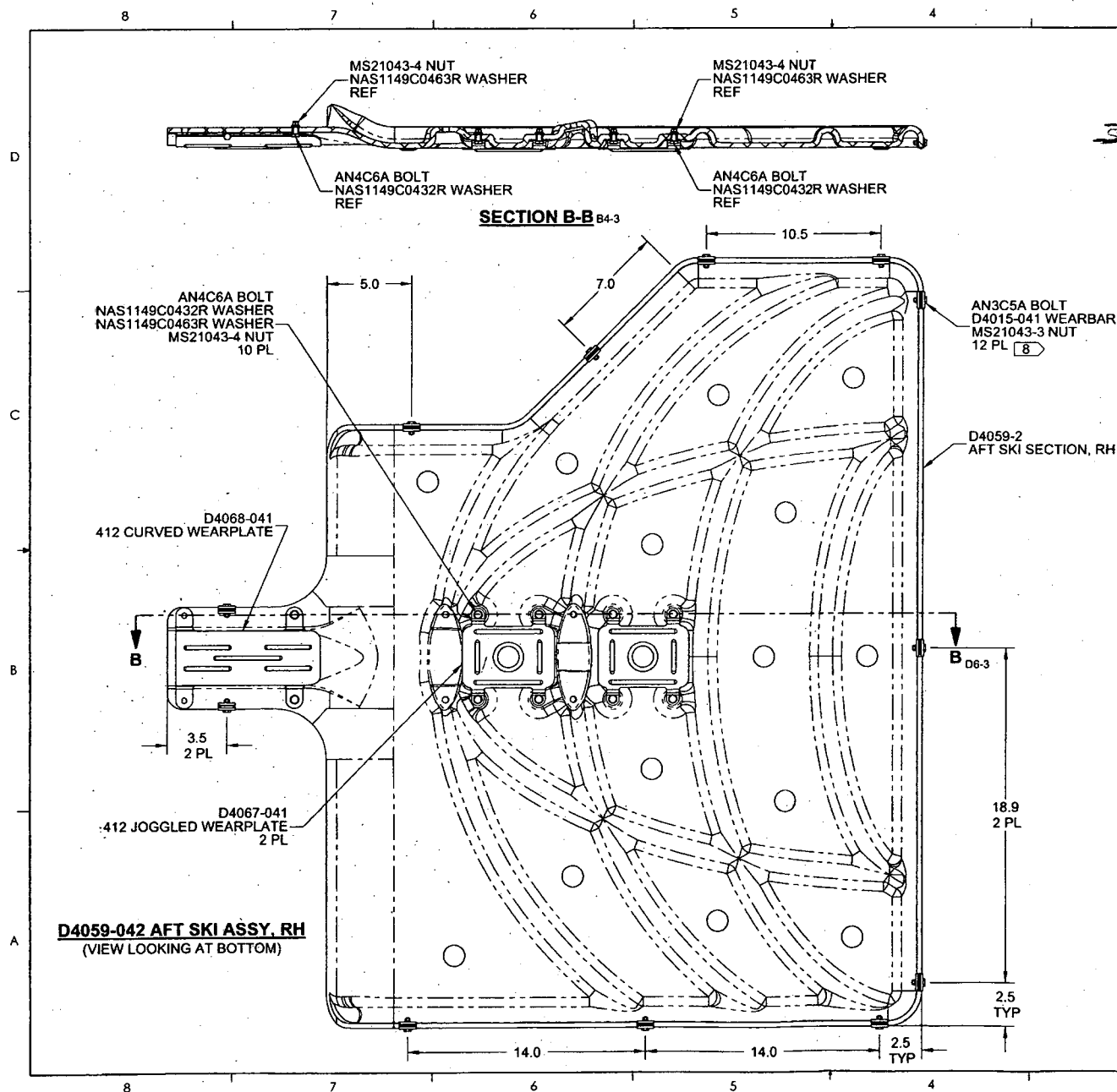
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 26.0 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN. TRANSFER DRILL  $\varnothing 0.191$ " HOLE FROM D4015-041 TO D4059-1. CHAMFER HOLE 0.03 X 45°.
- 9) TORQUE: AN3 NUTS = 15-20 in-lb  
AN4 NUTS = 50-70 in-lb

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4059</b>	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 6
APPROVED		<b>AFT SKI ASSY</b>	SCALE
DE APPR.			NTS
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4067-041



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-042	AFT SKI ASSY, RH
2	12	D4015-041	WEARBAR
3	1	D4059-2	AFT SKI SECTION, RH
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	12	MS21043-3	NUT
8	10	MS21043-4	NUT
9	10	AN4C6A	BOLT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

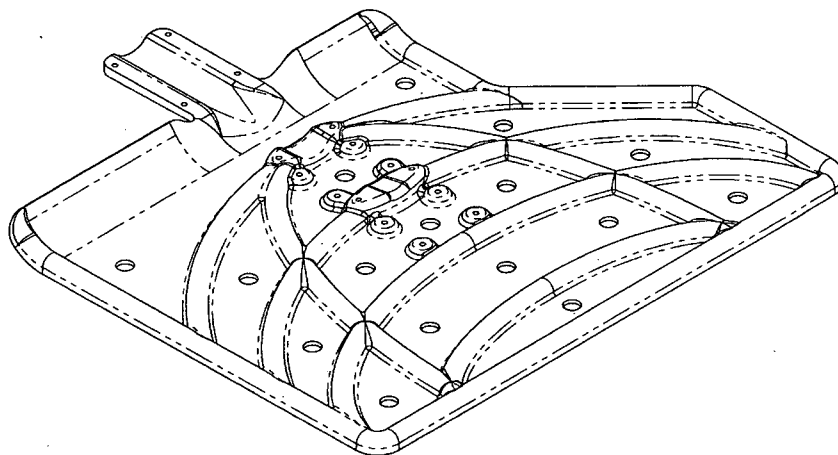
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2010-04-07  
*mp*

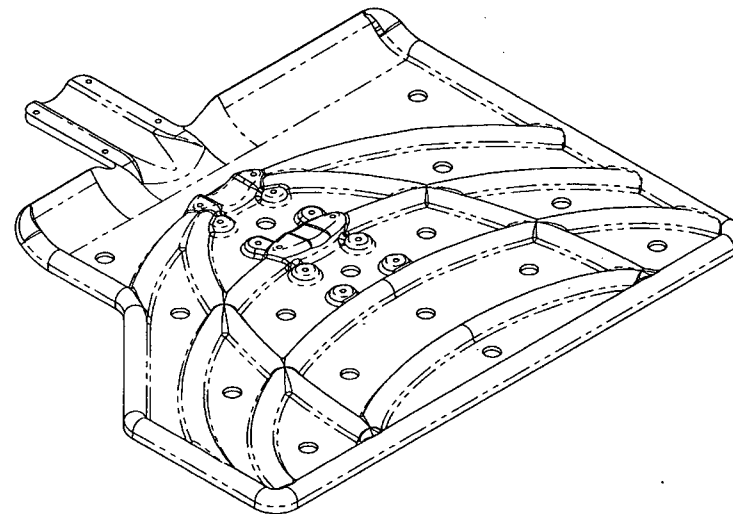
## D4059-042 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 26.0 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.  
TRANSFER DRILL Ø0.191" HOLE FROM D4015-041 TO D4059-2.  
CHAMFER HOLE 0.03 X 45°  
FASTEN USING PRESCRIBED HARDWARE
- 9) TORQUE: AN3 NUTS = 15-20 in-lb  
AN4 NUTS = 50-70 in-lb

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4059</b> REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE <b>AFT SKI ASSY</b> SCALE
DE APPR.	<i>[Signature]</i>	NTS
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**D4059-1 AFT SKI SECTION, LH**



**D4059-2 AFT SKI SECTION, RH**

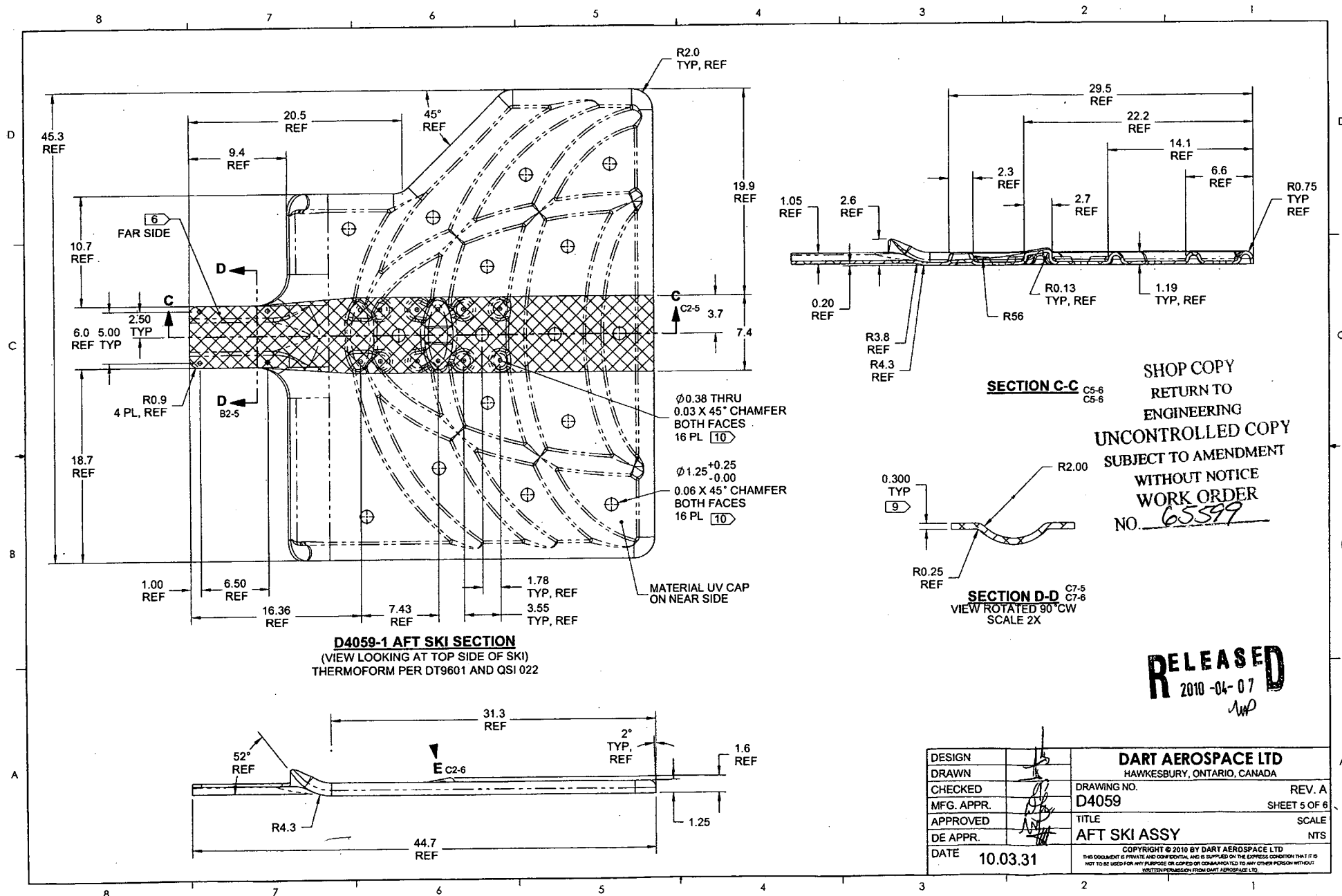
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**RELEASED**  
2010-04-07  
*WHP*

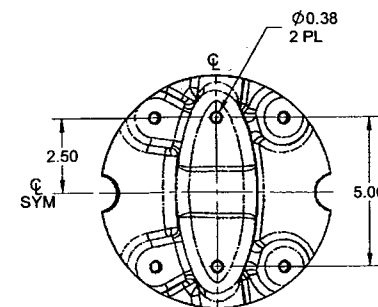
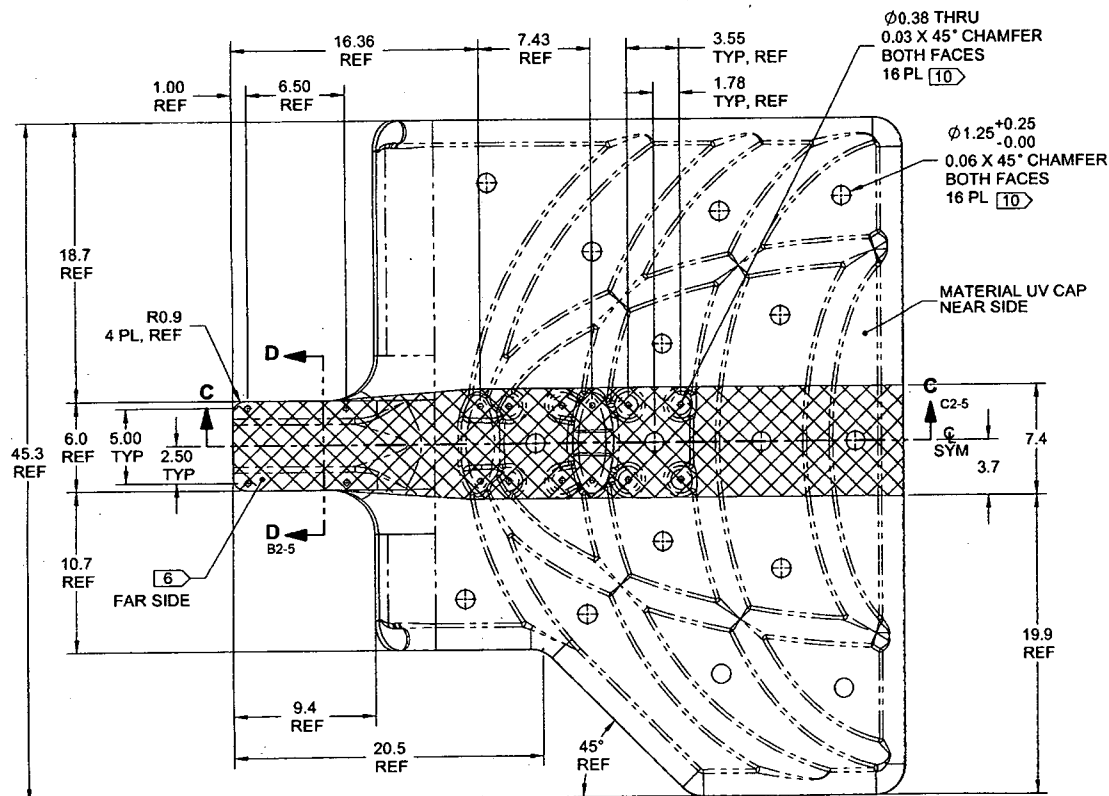
**D4059-1/2 NOTES:**

- 1) MATERIAL: ALEXTRA ET SHEET, 0.300 THICK  
REF. DART SPEC. M-ALXTRAB.300
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4059-X" AND B/N USING VIBRATING SYLUS
- 7) WEIGHT: 23.50 lbs EACH
- 8) THERMOFORMING: PER DT9601 (D4059-1) OR DT9602 (D4059-2) AND DART QSI 022
- 9) MINIMUM THICKNESS: IN SHADED AREA = 0.210  
OUTSIDE SHADED AREA = 0.175
- 10) PICK UP ON EXISTING MOLD MARKINGS AND DRILL THRU AS SHOWN

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4059</b>	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>AFT SKI ASSY</b>	NTS
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2010-04-07  
AWP

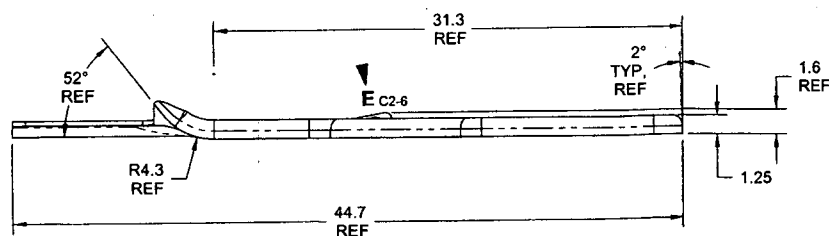


VIEW E-E  
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WORK ORDER  
NO. 65599

**D4059-2 AFT SKI SECTION**  
(VIEW LOOKING AT TOP SIDE OF SKI)  
THERMOFORM PER DT9602 AND QSI 022

**RELEASED**  
2010-04-07  
MHP



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4059</b>	REV. A
MFG. APPR.		TITLE	SHEET 6 OF 6
APPROVED		<b>AFT SKI ASSY</b>	SCALE
DE APPR.			NTS
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